

FIG. 1A

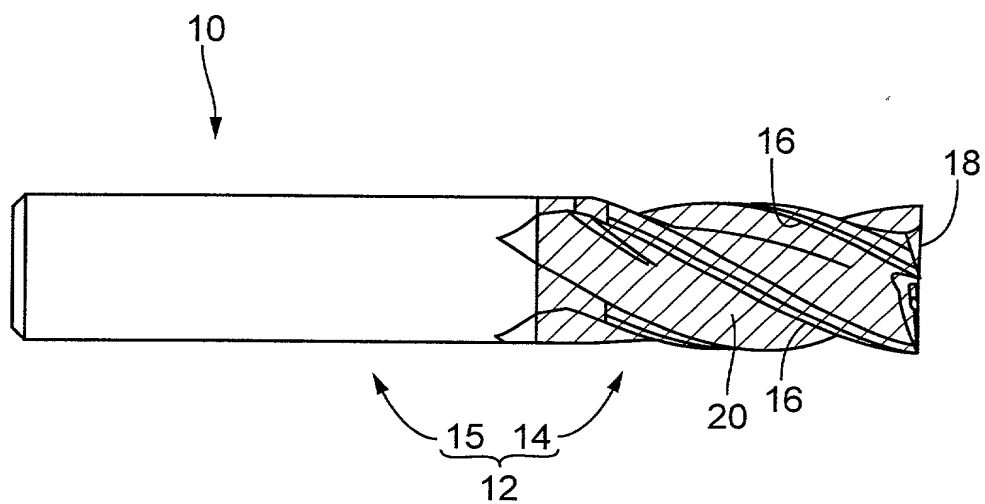


FIG. 1B

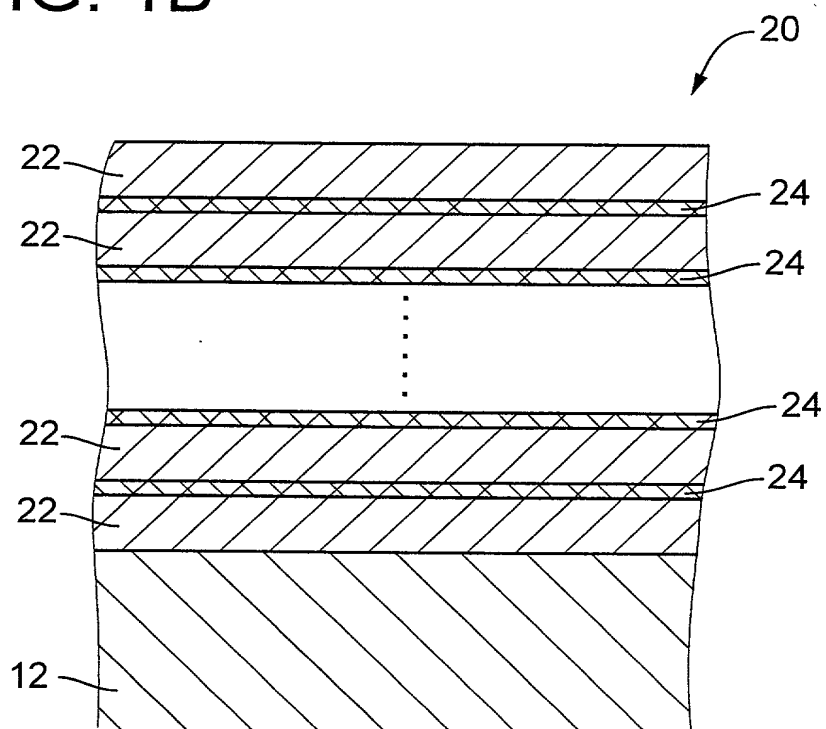


FIG. 2

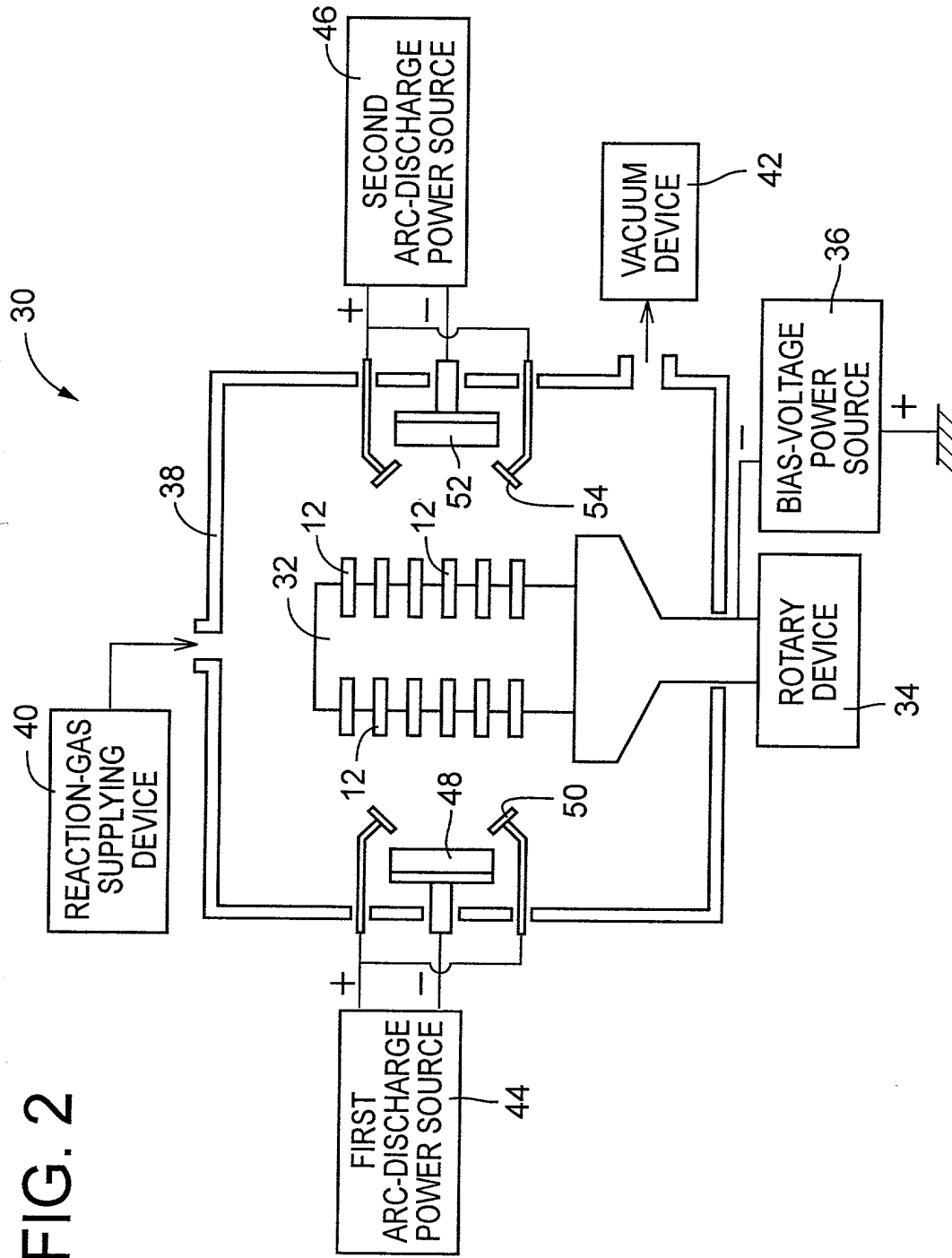


FIG. 3

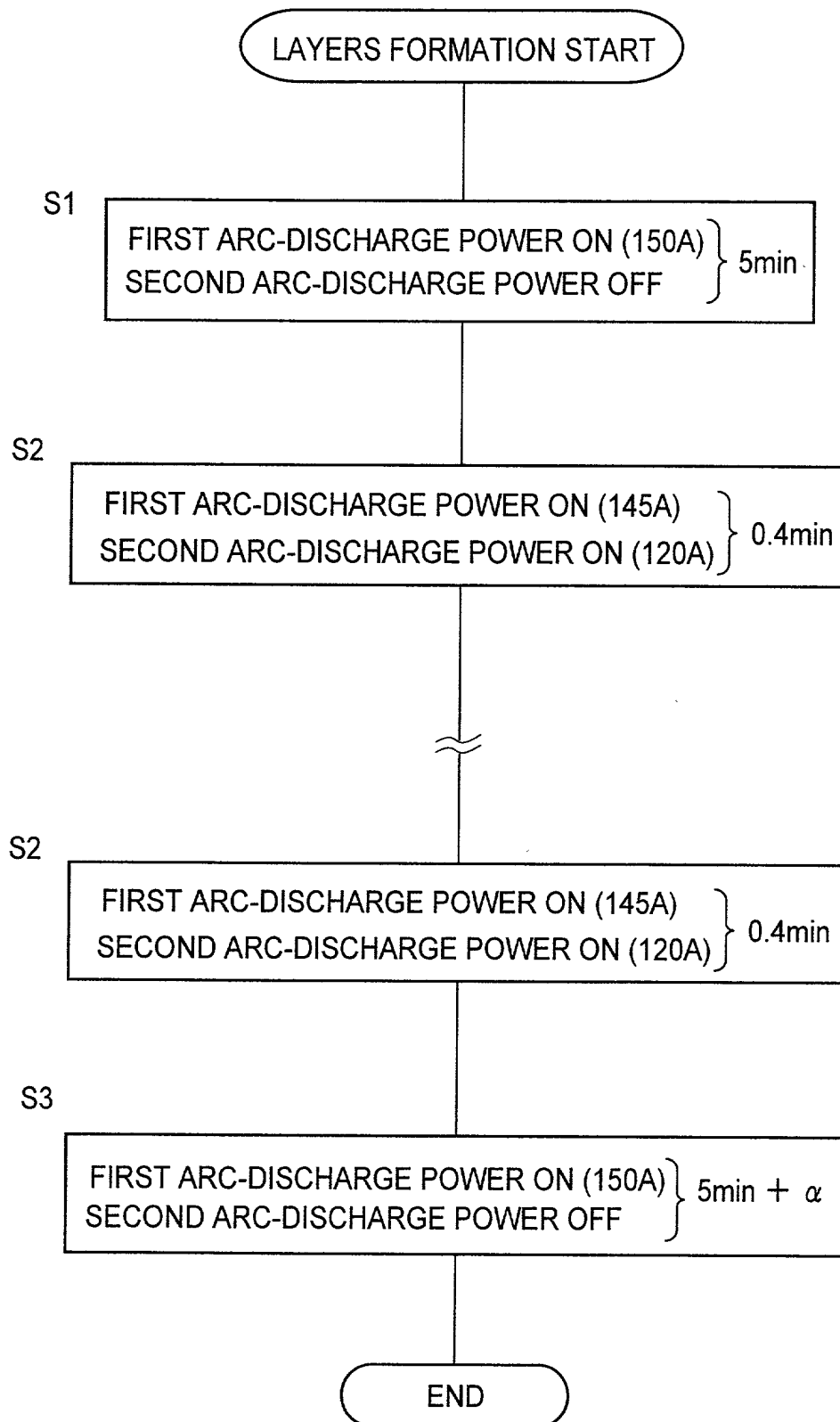


FIG. 4

Sample	No.	Coating						Chipp- ing	Worn width in peripheral flank faces (mm)
		(Ti _x Al _{1-x}) (C _y N _{1-y}) layer			CrN mixture layer	Number of layers	Total thick- ness (μm)		
		x	y	Thickness (nm)	Thickness (nm)				
Examples of the invention	1	0.5	0	430/500	50	11	2.9	LITTLE	0.038
	2	0.5	0	440/500	100	11	3.2	LITTLE	0.075
	3	0.5	0	240/300	200	11	2.5	SOME	0.043
	4	0.5	0	290/330	500	7	2.7	SOME	0.048
	5	0.5	0	960/1040	1000	3	3.0	SOME	0.099
	6	0.5	0	520/620	100	9	3.1	LITTLE	0.037
	7	0.5	0	310/370	500	7	2.8	SOME	0.041
	8	0.5	0	160/180	100	25	3.3	LITTLE	0.04
	9	0.5	0	950/1000	100	5	3.1	SOME	0.052
	10	0.4	0	340/380	20	15	2.9	LITTLE	0.032
	11	0.4	0	460/520	500	7	3.4	SOME	0.046
	12	0.2	0	390/450	100	11	2.9	SOME	0.102
	13	0.2	0	360/420	500	7	3.0	SOME	0.092
	14	0.5	0.2	420/500	100	11	3.1	SOME	0.098
	15	0.5	0.5	580/640	500	5	2.8	SOME	0.108
Compara- tive Examples	16	—	—	0	2200	1	2.2	LITTLE	0.39
	17	—	—	0	3900	1	3.9	LITTLE	0.45
Conven- tional Examples	18	0.4	0	2900	0	1	2.9	MUCH	0.211
	19	0.5	0	3400	0	1	3.4	MUCH	0.168
	20	0.8	0	3100	0	1	3.1	MUCH	0.322